

Work Order ID 69290 - *Split*

Friday, May 06, 2011 11:53:11 AM

Page 1

Item ID: D3564-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: *11/05/09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0 00



FLOW WATER JET

Waterjet

Memo

0 00

RB11-5-9

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: *D* Prog

3064 . 063

Rev *D* 2-Debur if necessary

110

0 00



QC2- Inspect parts off machine 1'AI/FAIB

QC

Memo

0 00

RB11-5-9

Quality Control

120

0 00



QC8- Inspect parts - second check

QC

Memo

0 00

Quality Control

5 11/05/09

(+12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 69290

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Page 2

Item ID: D3564-3

Revision ID:

Item Name: Wearshoe

Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Debur if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

0.00

0.00

SB 11/05/11

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/C

Memo

Ensure joggle as per dwg D3429

0.00

0.00

Sulista

(42)

150



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R Weld hardcoat as per Dwg D3437

0.00

0.00

2059B Hardcoat

M117659

EL/BL 11-6-7 (26)

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Required Date: 5/9/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

170

QC5- inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref 4 3 5 6) per QSI005 4 3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 115128

3200F

9:15

9:45

46

6X Ø m-f 11/06/08

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Page 4

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Item Name: Wearshoe

Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

6 0 BR 11-6-8.

200

Identify as per dwg & Stock Location

EP-19

0.00

Packaging

Memo

0.00

Packaging

6 BR 11-6-8.

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/6/9
MK
11-06-08

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NOTE: Date & initial all entries

Picklist Print

Friday, May 06, 2011 11:53:17 AM

Page 1

Work Order ID: 69290

Parent Item: D3564-3

Parent Item Name: Wearshoe



Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 cc
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	st	98.5000	1.1	13.89474			



304/316 Sheet 003



Kit 5-9

Location

Loc Qty

Loc Code

MA7020

98.5

117275

98.5

117275

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NOTE: Date & initial all entries

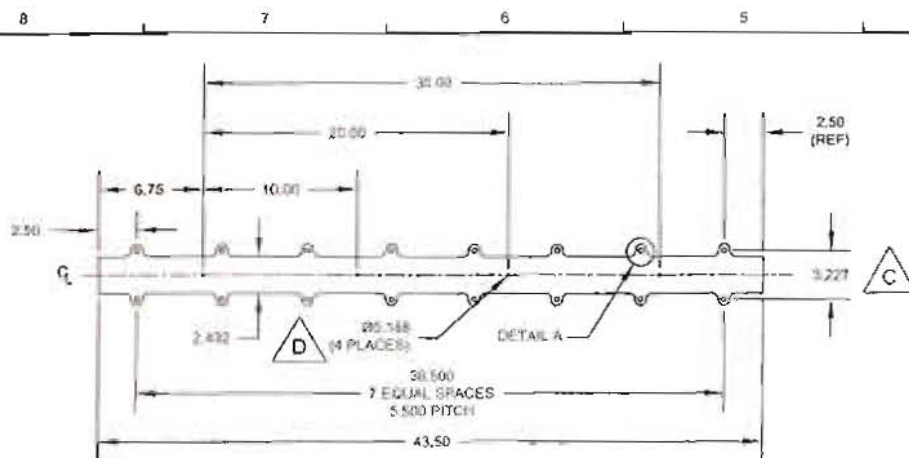
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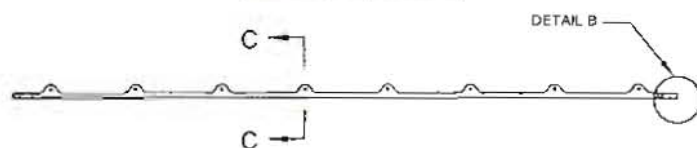
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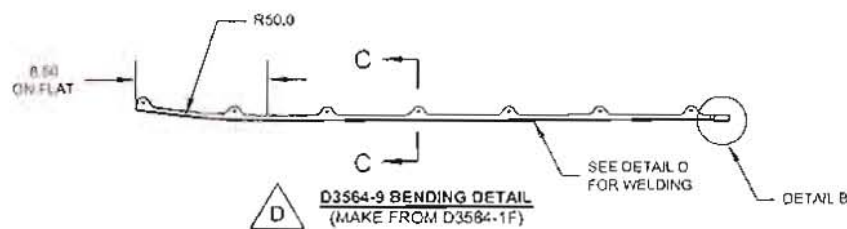
NOTE: Date & initial all entries



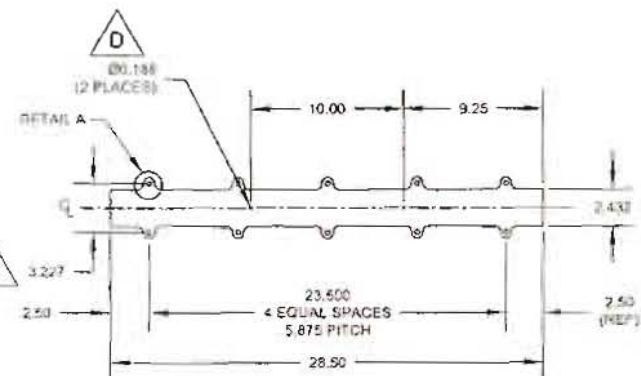
D3564-5F FLAT PATTERN



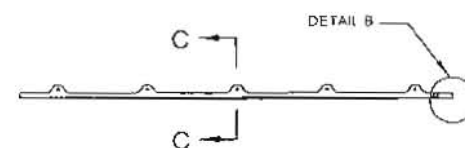
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



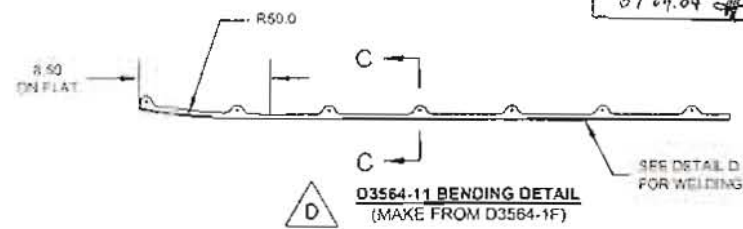
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.07.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG APPR	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR	PH	WEARSHOE	1:1
DATE	07.08.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

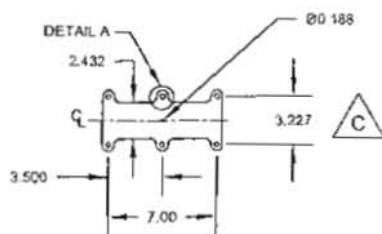
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

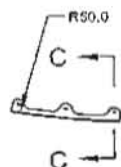
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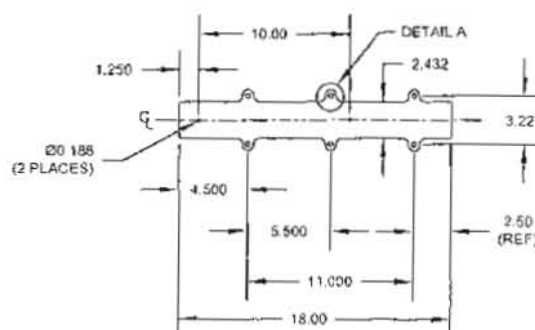
NOTE: Date & initial all entries



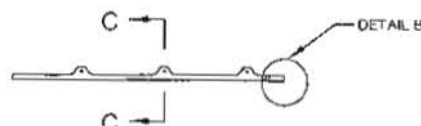
D3564-13F FLAT PATTERN



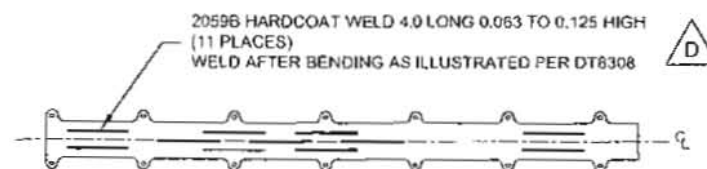
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



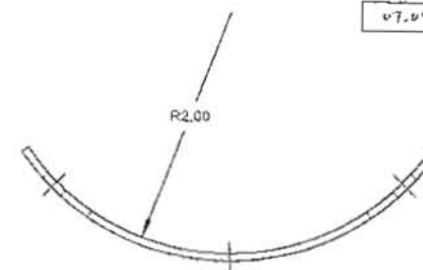
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



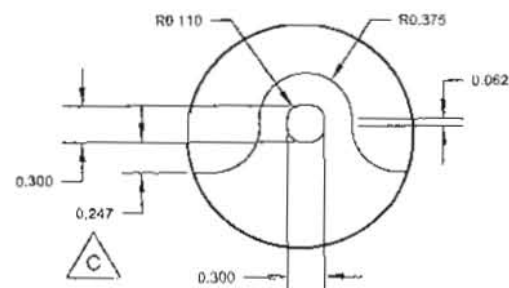
DETAIL D
(D3564-15/31-9/11 WELDING DETAIL)

RELEASED

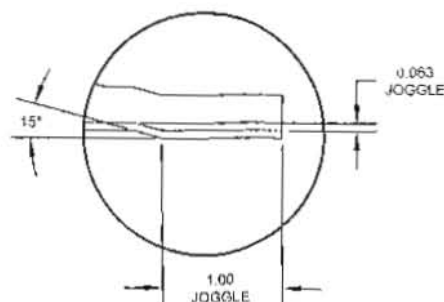
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO	REV D
MFG APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
QE APPR	PH	WEARSHOE	1:6
DATE	07.08.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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